

Date: Thursday, 10/04/2008 2:46:39 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: VERTICAL REF DOOR		
Job Number	: 38522			Part Number	: EA2046925		
Estimate Number	: 12741			Drawing Number	: D2046901		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/04/2008	S.O. No.	:	Drawing Revision	: 1		
Prsht Rev.	: NC			Material	:		
First Issue	: 10/04/2008	Type	: LARGE FAB ASSY	Due Date	: 11/04/2008	Qty:	1
Previous Run	: 30784			Um:	Each		
Written By	:						
Checked & Approved By	: 						
Comment	: rev A 07.02.21 new issue EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING 
Comment: PURCHASING ISSUE P.O. 6116 <i>C 208/04/10 ①</i> EAGLE COPTERS		
2.0	EA2046925	ARM SUB-ASSEMBLY 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) ARM SUB-ASSEMBLY		

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES 
-----	-----------------	---

Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty	Part Number	Description	Batch
1	EA20469-29	23	w/o 44499
1	EA20469-28		w/o 44499
1	EA20469-22		w/o 44499
1	EA20469-26		w/o 44499
1	EA2049-27		w/o 44499

Attach serviceable tags

Fabricate in accordance with D412-711

Certificate of conformity required


Apr 11/08

Date: Thursday, 10/04/2000 2:40:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REF DOOR

Job Number: 38522

Part Number: EA2046925

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0 QC5

INSPECT WORK TO CURRENT STEP



OK

Comment: INSPECT WORK TO CURRENT STEP

5.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



OK

Comment: INSPECT 100% KITS FOR COMPLETENESS

6.0 PACKAGING 1

PACKAGING RESOURCE #1



OK

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0 QC21

FINAL INSPECTION/W/O RELEASE



①

Do 04/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.04.11

EAGLE COPIERS MAINTENANCE LTD.

823 MONTAVISH ROAD, CALGARY, ALBERTA, T2E 5G9

DOT APPROVAL NO. **681**

Nomenclature

A-1

Part

No.

546-1550-61

Type/Model

Manufacturer

Part

No.

546-1550-61

Serial No.

4499

Total Line

4

Work Order

4499

T.S.O.

4499

Overhaul

Inspected

Tested

Repair

Modification

Removal

Previous Certification

N/A

The maintenance described has been performed in accordance with the applicable
Standards of Workmanship.

MAINTENANCE RELEASE

DATE

NAME OR AUTHORIZED INSPECTOR

LIC. NO. / STAMP

Details of outstanding work and other information on reverse

Eagle 37

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Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: VERTICAL REF DOOR		
Job Number	: 38522			Part Number	: EA2046925		
Estimate Number	: 12741			Drawing Number	: D2046901		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/04/2008	S.O. No.	:	Drawing Revision	: 1		
Prsht Rev.	: NC			Material	:		
First Issue	: 10/04/2008	Type	: LARGE FAB ASSY	Due Date	: 11/04/2008	Qty:	1
Previous Run	: 30784			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: rev A 07.02.21 new issue EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING	ISSUE P.O. <u>10116</u> <u>10/04/10 ①</u> EAGLE COPTERS
2.0	EA2046925	ARM SUB-ASSEMBLY
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	ARM SUB-ASSEMBLY
3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
	Comment: Sub-Contracting OUTSIDE SERVICES	

EAGLE

Pick:Qty Part Number Description Batch

- 1 EA20469-29 _____
- 1 EA20469-28 _____
- 1 EA20469-22 _____
- 1 EA20469-26 _____
- 1 EA2049-27 _____

Attach serviceable tags

Fabricate in accordance with D412-711

Certificate of conformity required

Date: Thursday, 10/04/2008 2:46:39 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REF DOOR

Job Number: 38522

Part Number: EA2046925

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0 QC21

FINAL INSPECTION/W/O RELEASE

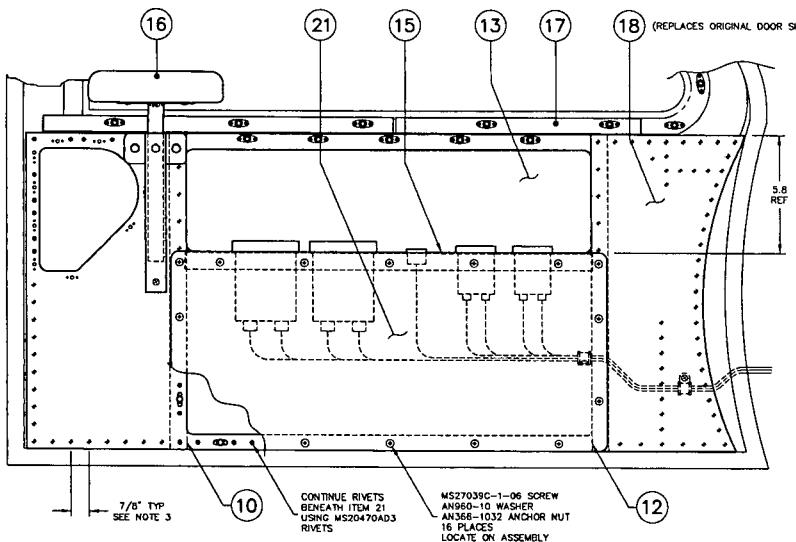
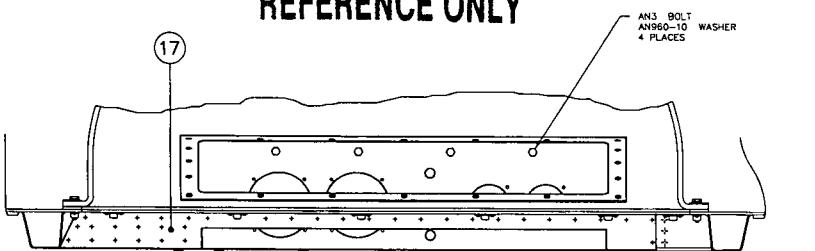


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



REFERENCE ONLY



② ASSEMBLY - DOOR MOUNTED INSTRUMENTS

NOTES

2. INSTALL ALL RIVETS IN ACCORDANCE WITH AC4.13-1B, PAR 4-58, AND FIG. 4-6
USING THE FOLLOWING LEGEND:

- Existing Rivet (Ref)

+ MS20470AD3

* MS20470AD4

o MS20426AD3

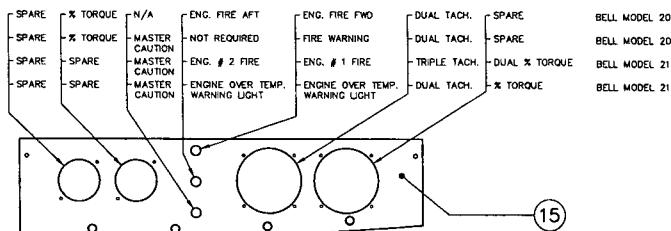
• MS20426AD4

3. PICK UP EXISTING RIVET HOLES IN DOOR THROUGHOUT ENTIRE PANEL.

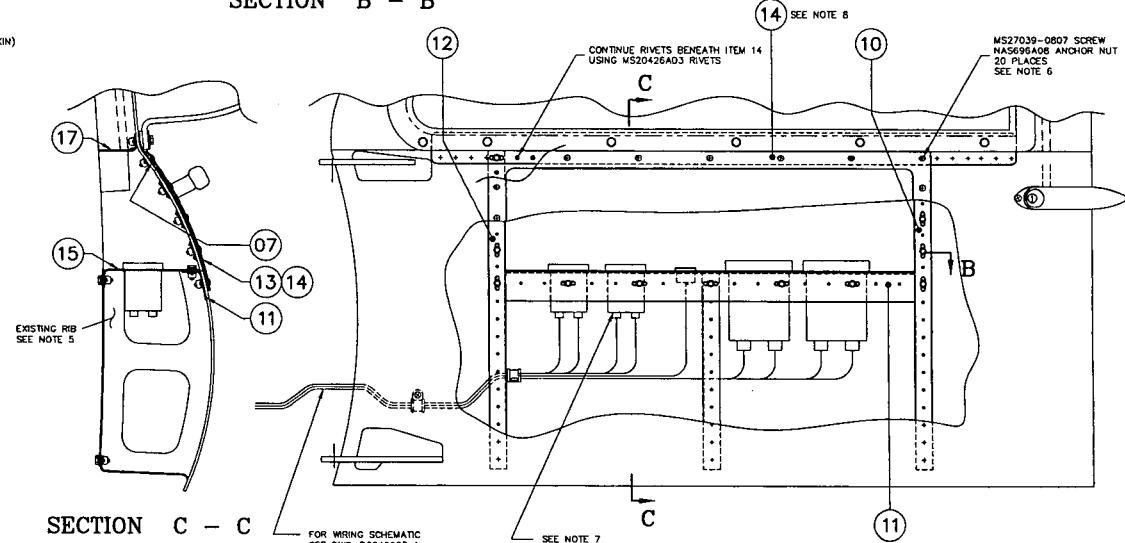
4. CUT DOWN EXISTING RIB AS SHOWN

5. DRILL HOLES IN DOOR AND INSTALL ANCHOR NUTS ON ASSEMBLY TO MATCH
HOLES IN PARTS 13 & 14.

7. INSTRUMENTS FITTED INTO DOOR ARE EITHER REMOVED FROM LEFT HAND INSTRUMENT
PANEL OR ARE PROVIDED AS EXTRA INSTRUMENTS. WIRING ROUTED THROUGH DOOR
AND BEHIND LEFT SIDE INSTRUMENT PANEL AND PLUGGED INTO LEFT SIDE INSTRUMENT
HARNESS. INSTRUMENT WIRING IN DOOR BUNDLED AND BOUND WITH CORD TO PROVIDE
PIGTAIL WITH LENGTH TO ALLOW FULL OPENING OF DOOR.



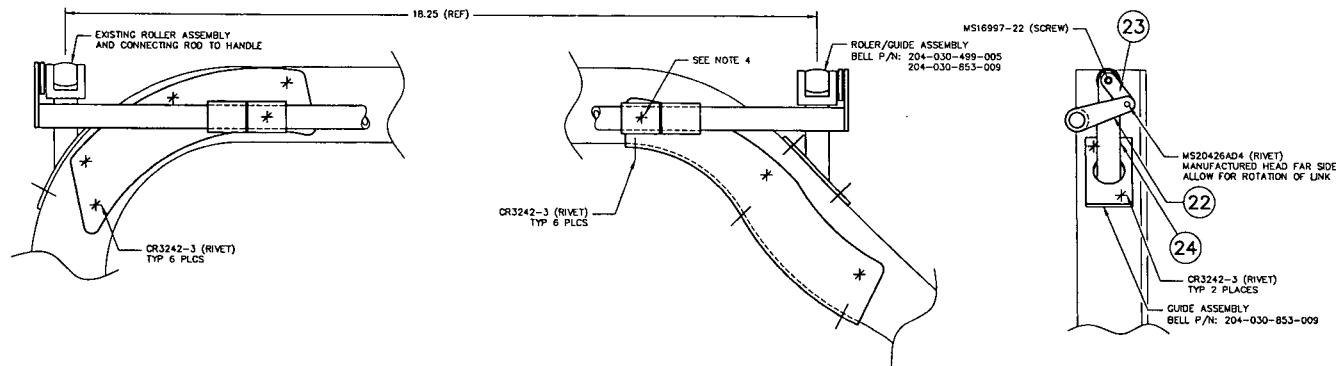
SECTION B - B



REFERENCE ONLY

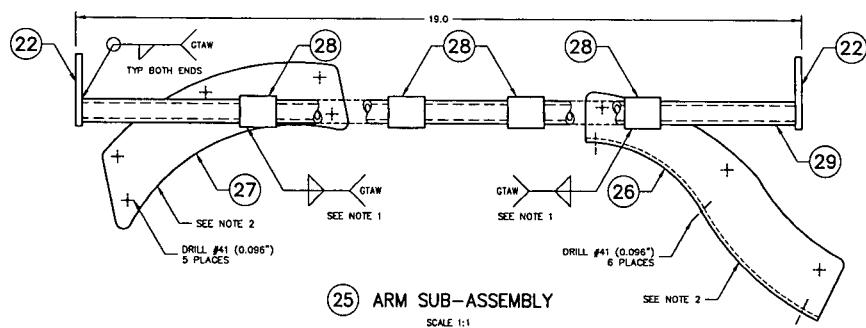
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 2000



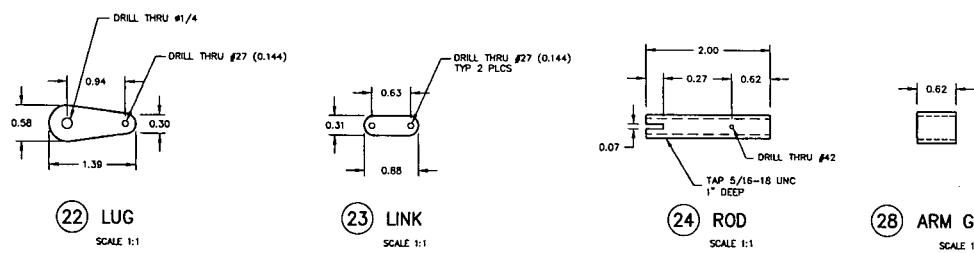
UPPER DOOR LATCH ASSEMBLY

SCALE 1:1



ARM SUB-ASSEMBLY

SCALE 1:1



(22) LUG

SCALE 1:1

(23) LINK

SCALE 1:1

(24) ROD

SCALE 1:1

(28) ARM GUIDE

SCALE 1:1

QTY.	ITEM NO.	DESCRIPTION	PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE
LIST OF MATERIALS						
	BASIC CODE	DASH NO. FOR MA NUFACTURED HEAD NEAR SIDE F=FORGED HEAD FAR SIDE	DASH NO. FOR LENGTH	APPROVALS	DATE	
	D=DIMPLE DIT=D # OF SHEETS TO BE DIMPLED C=COUNTERSINK			E. BURGIN	26 AUG 1991	
				CHECKED:		
				STRESS:		
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE IN THOUSANDS OF AN INCHES		
				DECIMALS X.XXX	±0.010	
				X.XXX	±0.03	
				X.X	±0.1	
				ANGLES	±1/2°	
				SCALE AS NOTED		
2	1	DASH NO.		DRW. SIZE	DRW. NO.	REV.
		DESCRIPTION				

BASIC CODES:	* INSTALL NEW RIVET	
BJ = MS2047040	+ REMOVE/REPLACE RIVET	
BU = MS2047040	X EXISTING RIVET	
LZ = MS2047040		
CX = MS2047000		
APPROVALS		
E. BURGIN		
DATE		
26 AUG 1991		
CHECKED:		
STRESS:		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE IN THOUSANDS OF AN INCHES		
DECIMALS X.XXX		
±0.010		
X.XXX		
±0.03		
X.X		
±0.1		
ANGLES ±1/2°		
DRW. SIZE	DRW. NO.	REV.
A1	D2046901	1
SHEET 3 OF 3		

AERO DESIGN LTD.

CONSULTING ENGINEERS, PLANT DESIGNERS, APPROVALS, DRAWINGS
1000 McTAVISH ROAD N.E., CALGARY, ALBERTA, T2E 7G9

BELL 204, 205, 212 & 214

VERTICAL REFERENCE DOOR
INSTALLATION

EAGLE COPTERS LTD.

REFERENCE ONLY

